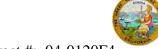
### **DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

## WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter **Report No:** WIR-022061 Address: 333 Burma Road **Date Inspected:** 20-Mar-2011

City: Oakland, CA 94607

**OSM Arrival Time:** 700 **Project Name:** SAS Superstructure **OSM Departure Time:** 1900 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

**CWI Name:** Mr. An Qing xiang / Mr. Liu hua j@WI Present: Yes No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A **Weld Procedures Followed:** Yes N/A N/A **Electrode to specification:** No Yes No N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A

N/A Yes No N/A **Approved Drawings:** Yes No **Approved WPS:** Yes No N/A **Delayed / Cancelled:** 

34-0006 **Bridge No: Component:** Orthotropic Box Girder (OBG)

## **Summary of Items Observed:**

This CALTRANS OSM Quality Assurance Inspector (QA) Surendra Prabhu was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG Trial Assembly open yard.

Segment: 12AE

This QA Inspector randomly observed the following work in progress:

Shielded Metal Arc Welding (SMAW) welding of weld joint identified as SEG3007K-026. Welder is identified as 037743. ZPMC Quality Control (QC) is identified as Mr. Liu hua jie. The welding variables recorded by QC personnel observed appeared to comply with Welding Procedure Specification (WPS): WPS-B-P-2113-FCM-1.

SMAW welding of weld joint identified as SEG3007ADA-032. Welder is identified as 037743. ZPMC QC is identified as Mr. Liu hua jie. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-P-2214-TC-U4b-FCM-1.

Flux Cored Arc Welding (FCAW) welding of weld joint identified as SEG3007G-010. Welder is identified as 050242. ZPMC QC is identified as Mr. Liu hua jie. The welding variables recorded by QC personnel observed

## WELDING INSPECTION REPORT

(Continued Page 2 of 3)

appeared to comply with WPS: WPS-B-T-2233-ESAB.

FCAW welding of weld joint identified as SEG3007G-011. Welder is identified as 050242. ZPMC QC is identified as Mr. Liu hua jie. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-T-2233-ESAB.

ZPMC personnel connecting the OBG segment identified as 13AW to the segment 12CW. See attached photos for further details.

OBG Assembly bay#14

Segment: 13BW

SMAW welding of weld joint identified as SEG3014-006. The welders are identified as 067572, 067764 and 066443. ZPMC QC is identified as Zhang Ling. The welding variables recorded by this QC appeared to comply with WPS: B-P-2214-B-U2-FCM-1.

Segment: 13CW

FCAW welding of weld joint identified as SA3232B-004. The welder is identified as 048696. ZPMC QC is identified as Zhang Ling. The welding variables recorded by this QC appeared to comply with WPS: B-T-2232-ESAB.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.





# WELDING INSPECTION REPORT

(Continued Page 3 of 3)





## **Summary of Conversations:**

No significant conversations were reported on this date.

### **Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhu,Surendra	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer